

Work Order ID 56054

February 9, 2010 1:24:17 PM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/09/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *JD* Date: 10-2-09 Tooling:

Date:

Stop



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3535	Rev B
-------	-------

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

B 10-2-16304.040

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-2-16

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8 w/02/16(+12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56054

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Page 2

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Setup Start



Revision ID:

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Item Name: Wearshoe

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23

9510/03/01

12

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

80/03/01

112

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

1112588

Memo

0.00

Powder Coating

START TIME: 3:15pm FINISH TIME: 3:45pm OVEN TEMPERATURE: 320°F

⇒ 10/03/01

112

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

BK

10-3-3

(12)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP.21

0.00

JA

10/03/03

(X12)

Ø



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 AJ

ME
10-3-2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February 9, 2010 1:24:21 PM

Page 1

Work Order ID: 56054



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 2/09/10

Required Date: 2/15/10

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	229.1294	11.4653	18.4	20.	



304/316 .040 Sheet

B10-2-16

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT	229.1294053	
110076	0.40253684	
112567	38.0765789	
112885	36.9578	
113062	145.1723	
113077	8.52018947	



113062

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DART AEROSPACE LTD		Work Order:	54054
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.890	✓			
2.000	+/-0.010	2.000	✓			
4.750	+/-0.010	4.750	✓			
9.500	+/-0.010	9.500	✓			
14.250	+/-0.010	14.250	✓			
17.750	+/-0.010	17.750	✓			
23.140	+/-0.010	23.140	✓			
28.530	+/-0.010	28.530	✓			
33.920	+/-0.010	33.920	✓			
39.310	+/-0.010	39.310	✓			
44.700	+/-0.010	44.700	✓			
48.200	+/-0.010	48.200	✓			
52.850	+/-0.010	52.850	✓			
Ø0.188	+0.005/-0.001	0.192	✓			
48.00	+/-0.030	48.00	✓			
39.00	+/-0.030	39.00	✓			
32.00	+/-0.030	32.00	✓			
24.00	+/-0.030	24.00	✓			
16.00	+/-0.030	16.00	✓			
8.00	+/-0.030	8.00	✓			
6.00	+/-0.030	6.00	✓			
0.300	+/-0.010	0.303	✓			
0.300	+/-0.010	0.301	✓			
0.038	+/-0.010	0.035	✗			

Measured by:	RB
Date:	10-2-16

Audited by:	S
Date:	10/2/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

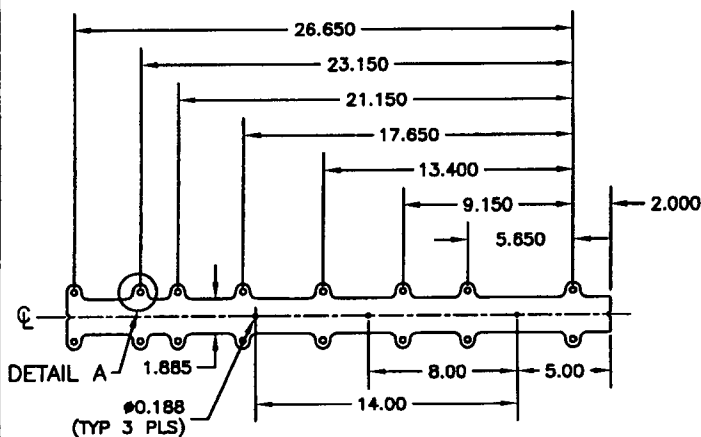
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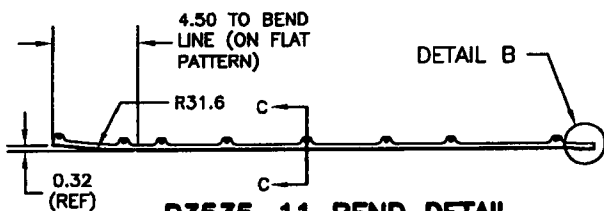
07.04.24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54054

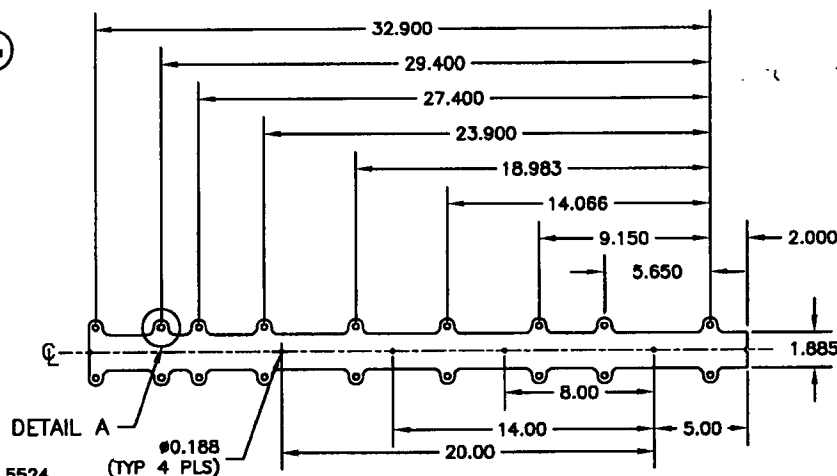
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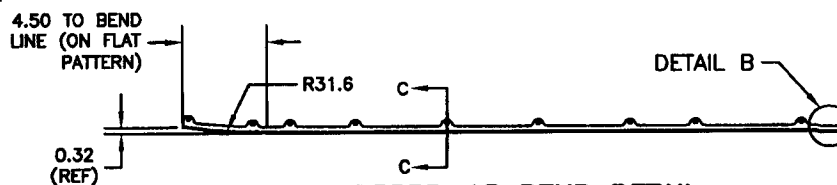
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE 1:10
A	NEW ISSUE	REV. B
07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

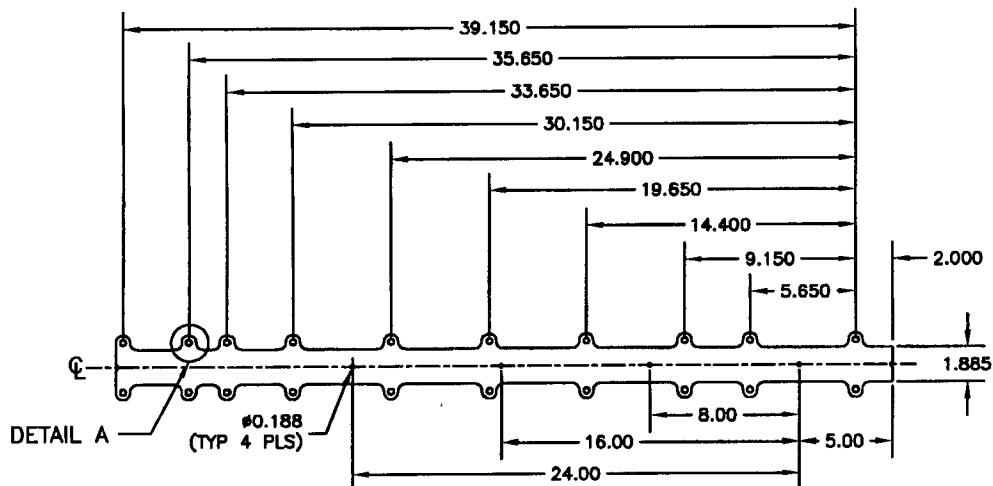
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NOTE: Date & initial all entries

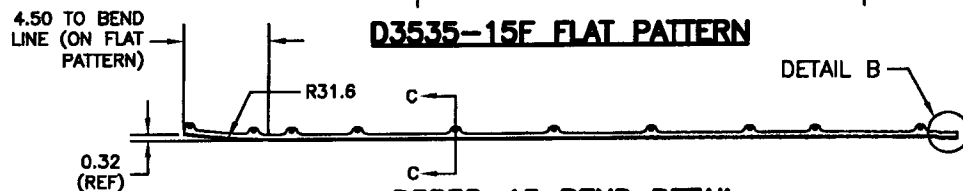
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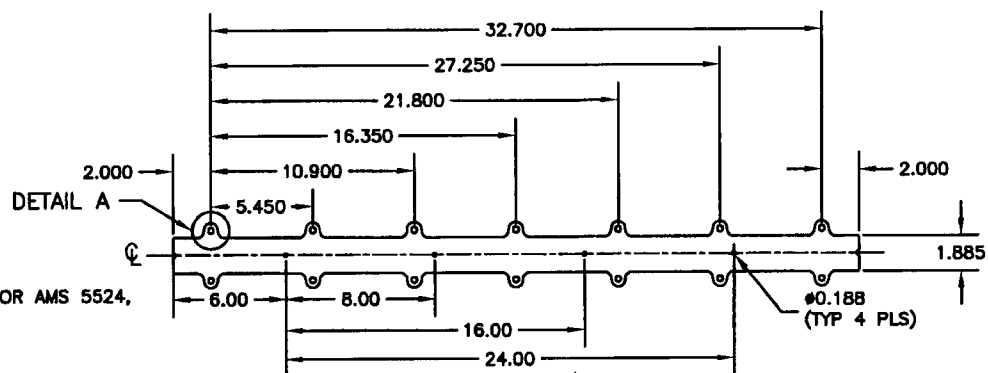
07.04.24



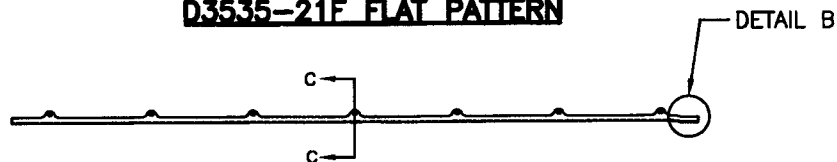
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL





D3535-21F FLAT PATTERN



D35.35-21 BEND DETAIL

- NOTES

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PAINT MARKER
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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 2 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10

11/10 26059

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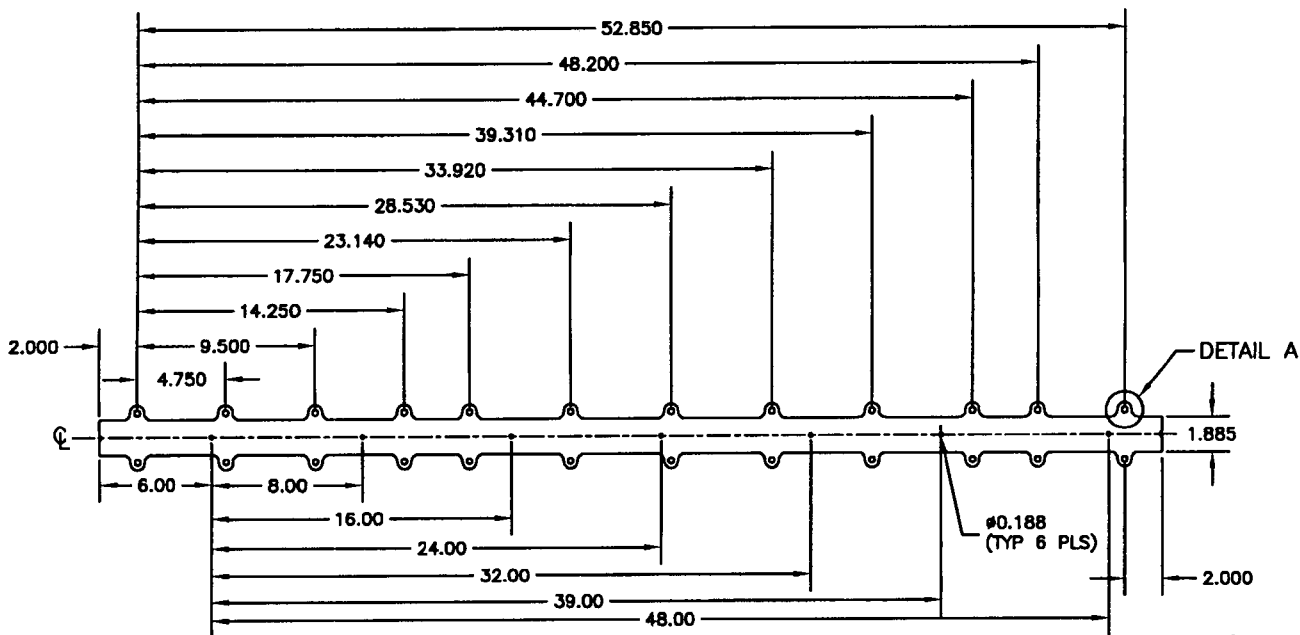
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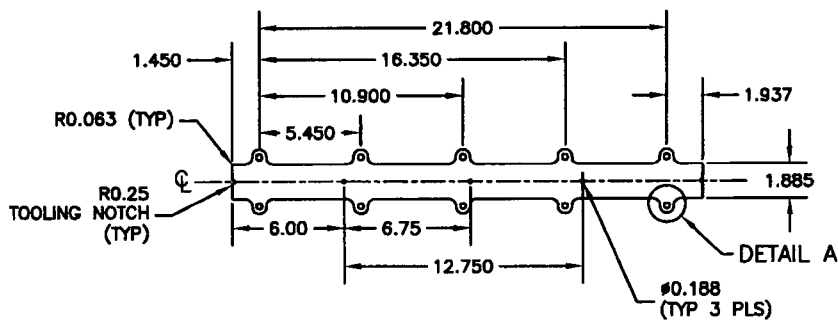
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07-04-24 #



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

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(REF DART SPEC M304S20GA)
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DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3535	REV. B SHEET 3 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10

W/0 56054

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Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

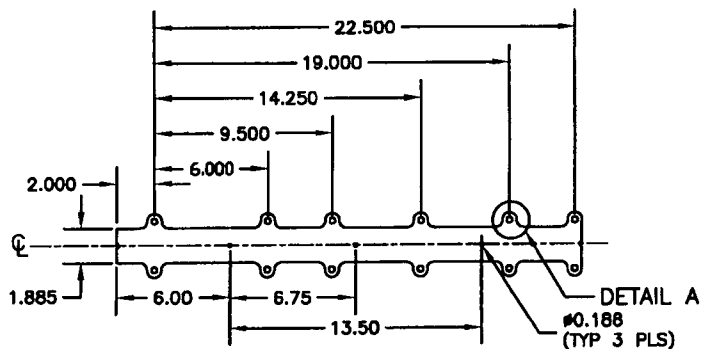
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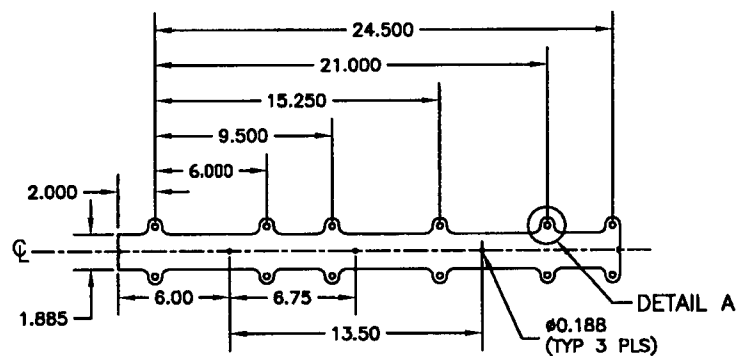
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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			WEARSHOE	SHEET 4 OF 7
				SCALE 1:10

11/10 54054

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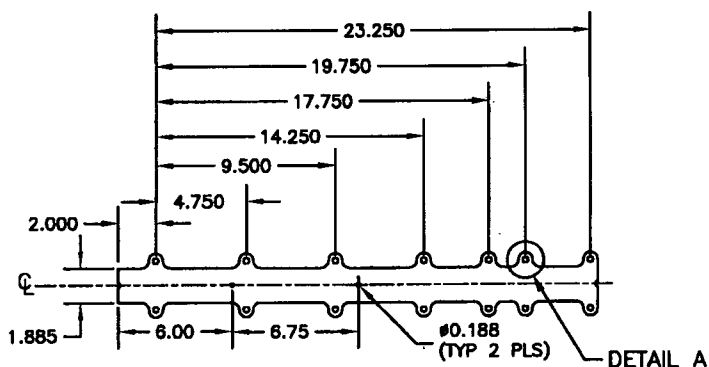
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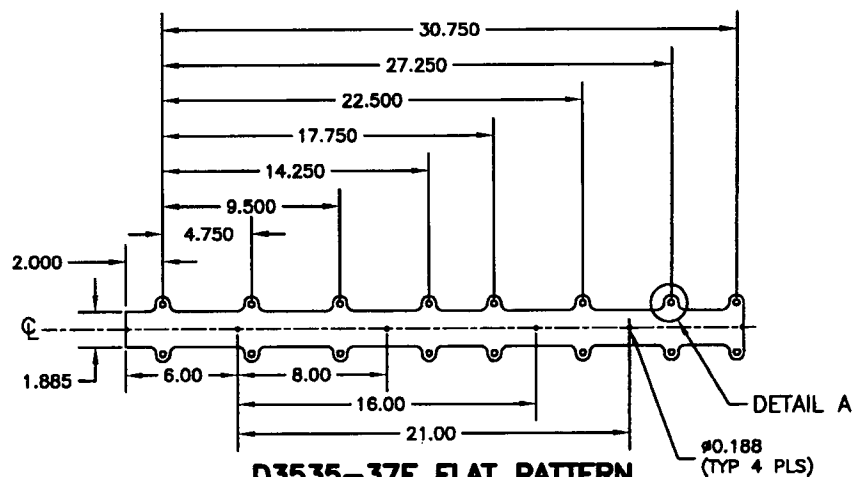
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	[Signature]	APPROVED	[Signature]	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 5 OF 7		
		REV. B		

W/H 56054

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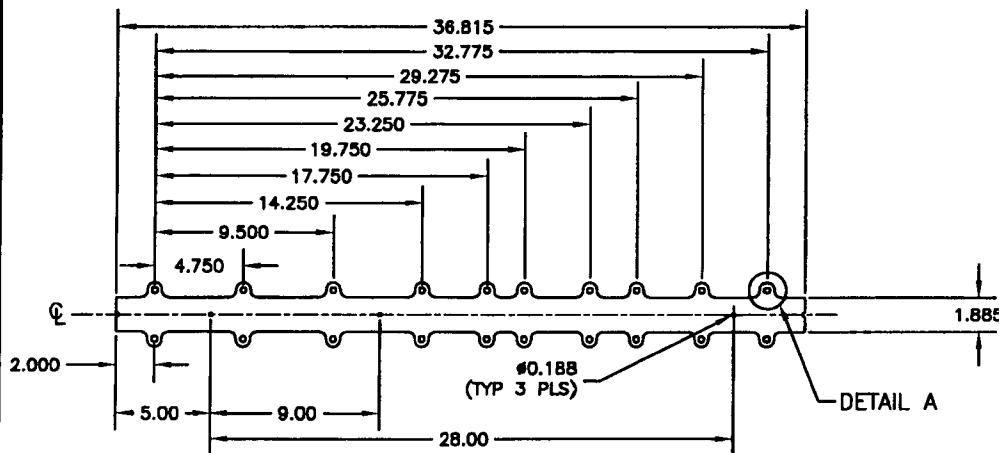
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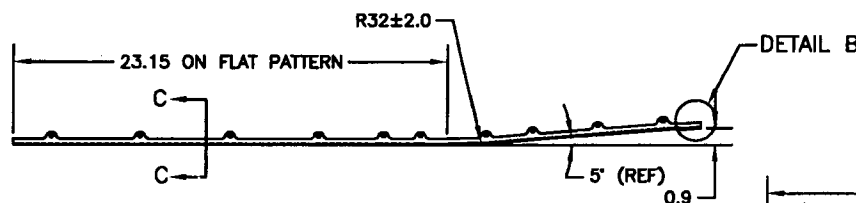
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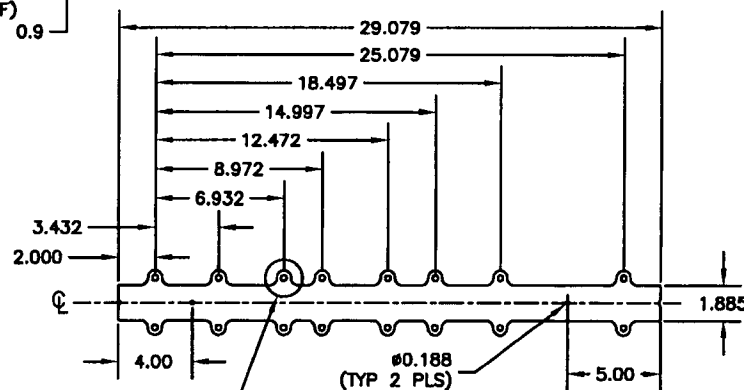
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



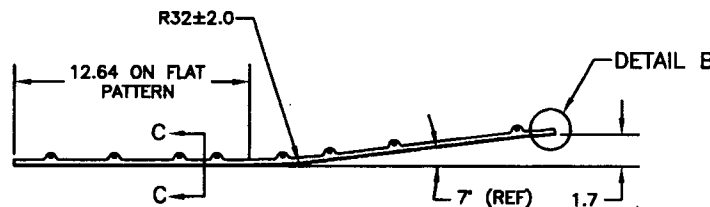
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

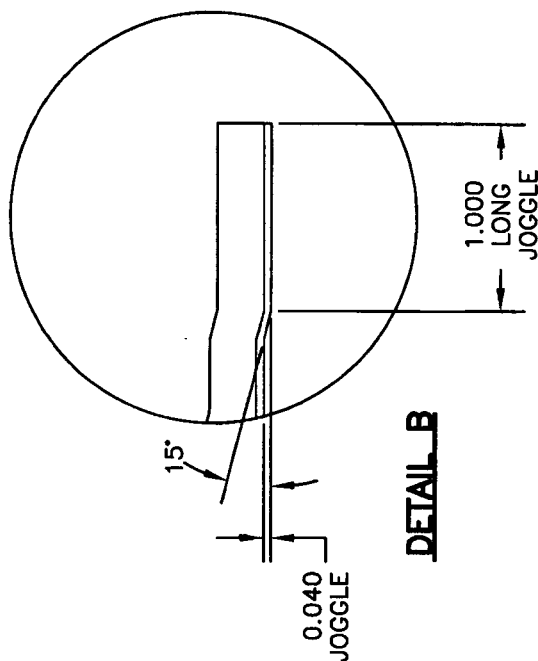
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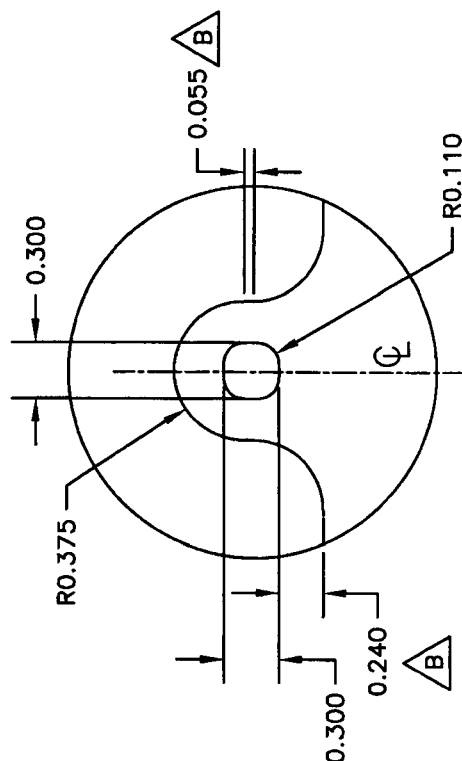
WLD 56054

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

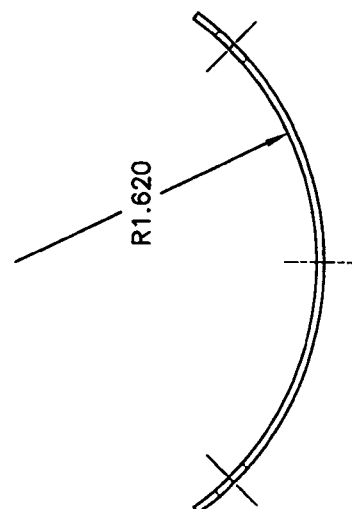
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07.04.24



DETAIL B



DETAIL A



SECTION C-C

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